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(54) METHOD FOR GRINDING TIP SURFACE OF PROJECTED NOZZLE OF SPINNERET

(57)Abstract:

PURPOSE: To provide a spinneret having projected nozzles having a high dimensional precision and giving fibers without denier unevenness, by filling and flattening the peripheral parts of many projected nozzles formed by penetrating and perforating a spinning plate with a filler, and subsequently grinding the tips of the projected nozzles.

CONSTITUTION: When the tip surfaces of the projected parts 5 of many projected nozzles 6 penetrated and perforated in the surface plate 1 of a dish-shaped spinneret having an inner diameter of 100mm, a flange outer diameter of 120 mm, a thickness of 1mm, and a depth of 10mm are ground, the peripheral parts of the projections 5 of many projected nozzles 6 are filled with a filler 8 into a flat surface, and the tip surfaces of the projected nozzles 6 are ground by the rotation of a round buffing bar 7, followed by dissolving off the filler 8. Since the filler 8 and the tip surfaces of the projected nozzles 6 are simultaneously ground with the grinding material such as buff, the tip parts of the projected nozzles 6 are ground without being buried in the grinding material, and the peripheral parts of the projections are not ground into a round shape. The tip end surfaces of the projected nozzles of the spinneret are thereby ground, while the irregularities of the dimensions of the tip surfaces are reduced.

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